	er ID 122941 , 2014 2:26:28 PM		*122	941*					10·		Page 1
Item ID: Revision ID:	D3572-5 Bracket		Accept	*N900	<b>040</b>	100	<b>)*</b> s	etup	Start Stop	*N:	S1* S2*
	7/29/14 Start Qty: 10. 7/29/14 Req'd Qty: 10.			Cust Item I Customer:	D:						
Reference: Approvals:	Process Plan: wm	Date: 1 30 14	Tooling: SPC (Y/N):		ate:		R		Start Stop	*N  *N	R1* R <i>2</i> *
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr										
D3572	Rev D										
*100 *100* Waterjet FLOW CNC Waterjet $\hat{O}O(\varrho l. 030$			0.00  0.00  Prog Rev:	2-			<u></u>			DC 14	10/23
*110 *110* QC	QC2- Inspect parts  Memo	off machine FAI/FAIB	0.00			•	8		2	foery,	10/22
120 *1 20* OC	QC8- Inspect parts		0.00				(15)				DAS 38 9-89
Quality Control	1722210										OCT 2 4 2014

Quality Control

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	$\boldsymbol{\vdash}$	Cracks				Broken/Damage/Defect	⊢	Hardwa		.,	Part Incorred	<u>-</u>	Temperature/Cure Weld
	<del></del>	-	nk/Ripple	/Wave		Burrs	⊩	4 '	ion Incomplete/Unqualifie	_	Part Lost/Mi	ssing	Wrong Stock Pulled
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Work Order ID 122941

Packaging

\*122941\*

Page 2

Tuesday, July 29, 2014 2:26:28 PM Accept \*N900040100\* Setup Start D3572-5 Item ID: **Revision ID:** Bracket **Item Name:** \*10\* **Start Oty:** 10.00 7/29/14 **Cust Item ID: Start Date:** Required Date: 7/29/14 **Req'd Qty:** 10.00 \*10\* **Customer:** Reference: Run Start Tooling: Process Plan: Date: Date: Approvals: Stop Date: \_\_\_\_\_ SPC (Y/N): Date: Reject Tool # Plan Reject **Tool ID** Accept Insp. Set Up/ Sequence ID/ Operation Qty Number Stamp Code Qty **Work Center ID Description Run Hours** 0.00 130 OCT 2 7 2014 NC BRAKE \*130\* 0.00 Brake NC Memo form bend as per Dwg D3572 usin DT8943 Brake NC DAS QC5- Inspect part completeness to step on W/O 0.00 140 38 \*140\* 9-89 0.00 QC Memo OCT 2 8 2014 **Quality Control** Identify as per dwg & Stock Location: WACO 0.00 DAS 150 OCT 2 7 2014 \*150\* 0.00 Packaging Memo

\*\*\*\*\*STOCK IN LARGE FAB\*\*\*\*\*

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DQA:			Date:											
OA Clasade			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UP		ork Order up	ndate only	AEROSPACE	
QA Closed:			Date.	*******							•			
Work Orde	er:					DISPOSITION		AGAINST DEPARTMENT/PROCESS						
	-					Rework			Skid-tube	Crosstube		Water Jet	Engineering	
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
	-					Use-as-is		Thern	noforming	Finishing	Rec/Stor	re/Packaging	Other	
NCR N	lo.					Suspected Unapproved			Large Fab	Composite		Supplier		
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		Turning S				Finish		4	Calibration					
	-	Wave/Tw				Fit/Function		Out of S	Sequence					

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\*122941\* Page 3 Tuesday, July 29, 2014 2:26:28 PM Accept \*N900040100\* Setup Start Item ID: D3572-5 **Revision ID:** Stop **Item Name:** Bracket \*10\* **Start Qty: 10.00 Cust Item ID:** 7/29/14 **Start Date:** Required Date: 7/29/14 Req'd Qty: 10.00 \*10\* **Customer:** Reference: Run Start Tooling: Date: Date: Process Plan: **Approvals:** Stop SPC (Y/N): Date: Date: QC:\_ Tool # Plan Reject Reject Insp. Tool ID Accept Set Up/ Sequence ID/ Operation Code Qty **Qty** Number Stamp Description **Run Hours Work Center ID** 0.00 160 QC21- Final Inspection - Work Order Release \*160\*

0.00

Memo

Quality Control

QC

DQA:			_ Date:										"DART
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE			F	AEROSPACE
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## **Picklist Print**

Tuesday, July 29, 2014 2:26:28 PM

Work Order ID: 122941

\*122941\*

Parent Item:

D3572-5

\*D3572-5\*

Parent Item Name: Bracket

**Start Date:** 7/29/14

Required Date: 7/29/14

Page 1

**Start Qty: 10.00** 

Required Qty: 10.00

**Comments:** 

IPP Rev : A New Issue 07-01-16 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date St Issued	tatus
M6061T6S.080		Purchased	No	-4			sf	470.9760		0.30015			1 1
*M6061 T6	SS 080*								**			DCM	10/2
				Location		Loc (	<u> Oty</u>	Loc Code					
				MAT021		29	0.11						

<b>Location</b>	Loc Oty	Loc Code	
MAT021	290.11		
m126309	130.52		
m126350	13.34		
m128903	146.25		
TPI	180.866		
m129439	180.866		
130560			.9479

DQA:			Date:											TRACC"
						WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE					AEROSPACE
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Work Orde	er:					Rework			Skid-tube Crosstube			Water Jet		Engineering
Part N	lo.					Scrap			Machining Small Fab	-	Pro	d. Eng. Coor.	П	Quality
				u <del>n</del>		Use-as-is		Thern	noforming Finishing		Rec/Stor	e/Packaging		Other
NCR N	No.			· · · · · ·		Suspected Unapproved			Large Fab Composite			Supplier		
Root					Desc	ription of work order update		nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verificatio	n	QC Inspector
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	<u> </u>	Centre No	ot Concer	itric	-	Broken/Damage/Defect	┝	Hardwa	uro.	$\vdash$	Part Incorred		_	Temperature/Cure
·	$\vdash$	Cracks Crimp/Kir	ماد / Diamba	Mayo		Burrs	$\vdash$	4	ion Incomplete/Unqualified	-	Part Lost/Mi		-	Weld
	_	Cuffs	ik/kibbie	/ vvave	·	Contamination	-	4 '	tions Incomplete/Unclear		Part Moved	B	$\vdash$	Wrong Stock Pulled
	$\vdash$	Crushing			-	Countersink		1	gned/off center		Positioned V	Vrong		3
	$\vdash$	Heat Trea	<b>a</b> t		<u> </u>	Cut Too Short		Mislabe		$\vdash$	Power Loss/			Other
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		Marks/Ch	•	· ubc	-	Drill Holes	-	Off-set						
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	$\vdash$	Wave/Tw			-	Fit/Function		-	Sequence					

DART AEROSPACE LTD	Work Order:	122941
Description: Bracket	Part Number:	D3572-5
Inspection Dwg: D3572 Rev: D		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	1.010	1		V=3KM-0 L	
5.25	+/-0.030	5.260	-			
0.080	+/-0.010	:077				
		<u> </u>				
				<del></del>		
						<u>,                                     </u>
		L	DAS			

Measured by: Dc/EZ Audited by: 38 9-89 Prototype Approval: N/A

Date: /Y/\oscite{Approval} Date: N/A

Date: OCT 2 4 2014

Rev	Date	Change	Revised by	Approved
L A	07.05.01	New Issue	KJ/JLM	Approved
В	09.12.14	Dwg Rev updated	KJ &	11
			( <del>X)</del>	

5 2 2 ITEM QTY -041 QTY -043 QTY PART NUMBER DESCRIPTION D3572-041 GUIDE ASSEMBLY х D3572-043 GUIDE ASSEMBLY (UH-1) SHOP COPY D3572-044 GUIDE ASSEMBLY (UH-1) (OPP) RETURN TO D3572-1 TURE 11 ENGINEERING D3572-3 \_\_\_\_ 4 GUIDE D D3572-5 BRACKET 13 3 3 TINCONTROLLED COPY 14 D3572-7 DELETED AT REVIC SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER D3572-041 GUIDE ASSEMBLY D3572-043 GUIDE ASSEMBLY (UH-1) D3572-044 GUIDE ASSEMBLY (UH-1) REDRAWN IN "B" SIZE FORMAT TO CURRENT STANDARDS. ADD -043, -044 FOR UH-1. SEE PAR 09-017. 09.04.17 REMOVE D3572-7 LE 07.06.01 В FOR D3573-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET LE 07.04.20 NOTES: 1) MATERIAL: NONE A NEW ISSUE 07.03.29 LE REV. DESCRIPTION 1) MATERIAL: NOTE:
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED BY DATE DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3572-XXX" USING FINE POINT PERMANENT INK MARKER REV. D D3572 MFG. APPR. SHEET 1 OF 4 7) WEIGHT -041: 1.34 lbs TITLE APPROVED SCALE -043/-044: 1.42 lbs **GUIDE ASSEMBLY** DE APPR. 8) WELDING: PER DART QSI 004 NTS COPYRIGHT © 2007 BY DART AEROSPACE LTD
THIS COCCUSION IS PRIVATE AND CONFIDENTIAL MID IS SUPPLED ON THE EXPRESS CONCUSION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COMPANDATION TO ANY OTHER PRESCRIPTION. DATE 09.04.17





